



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18560-5
Job Sheet 170702



Part No: RBT18560-5

Job Qty: 6 ea

Part Name: Screw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/18/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18560 Rev4 IPP Rev A 17.11.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/30/18	0.00	0.00	Start Up Machining-4		J.C.L. 18-02-19
120	Lathe Conv	6 pcs		1/31/18	0.00	0.60	Lathe Conv-2		J.B. 18-02-19
130	QC	6 pcs		1/31/18	0.00	0.00	QC2 Machining-3		J.B. 18-02-19
135	QC	6 pcs		1/31/18	0.00	0.00	QC8 Machining-3		J.B. 18-02-21
140	Outsource	6 pcs		1/31/18	0.00	0.00	Outsource12		J.B. 18-02-21
150	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging2		J.B. 18-02-21
160	QC	6 pcs		1/31/18	0.00	0.00	QC6		J.B. 18-02-21
180	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging3		J.B. 18-02-21
190	QC21-SA	6 Ea		1/31/18	0.00	0.00			J.B. 18-02-21

Part Op 120 - Cut to length and deburr

Descriptions: 140 - Issue P/O to Groupe Altech; PO 03908 - Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98750A483	Threaded Rod 1/2-20 UNF x 4"	6 Ea (1 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/18/18 1:21 PM Dart.lajeunesse.marie

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
NCR No. _____		Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
		Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
		Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐
Date :	Step #:	QTY Effective				MRB (QS1042) Approval					
Description Work Order Deviation											
Root Cause				F							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐				
Design	☐	Operator	☐	Bending	☐	Set-up	☐				
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐				
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Def	☐				
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete	☐				
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐				
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐				
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐				
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete	☐				
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐				
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

DATE: 02/19/18

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@datarspace.com
www.datarspace.com

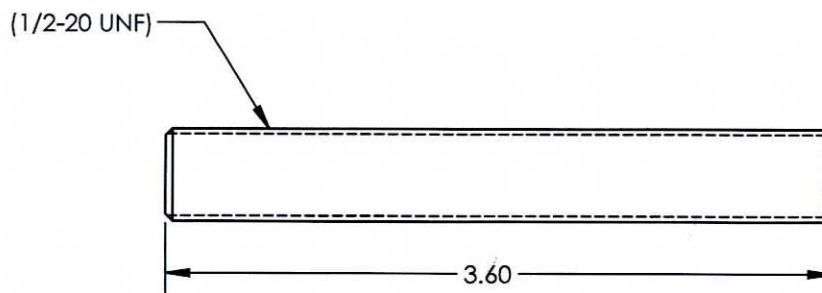
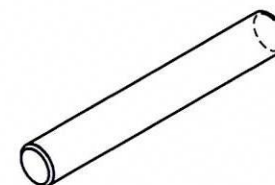
DATE: 02/19/18

Container No: S043550
Part: RB18560-5
Job No: 170702
Serial No/ Batch: S043550
Revision: RB18560
Inspector:



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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 17027 MJS
18-01-12

(5)
SCREW

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-5	REV 4
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED:	.015 x 45° OR .015R
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY
QA APPR:	AFTER PLATING
APPROVED: WEIL	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	SEE SHT 1
SCALE 1:1	DATE 5/2/2002
	SHEET 4 OF 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



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BLANKET PURCHASE ORDER PO039090

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			-Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required							
Line Item Note		Parts made from T-4140								
	170597			Firmed	3/1/18	6 pcs	0 pcs	6 pcs	\$1.05/pcs	\$6.30
Sub Total:						6	0	6		\$6.30
8		RBE350A93-3303-02-7	Stud Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	-		0 pcs	0 pcs	0 pcs	\$1.79/pcs	
Line Item Note		parts made from Black Oxide Steel								
	170598			Firmed	3/1/18	20 pcs	0 pcs	20 pcs	\$1.79/pcs	\$35.80
Sub Total:						20	0	20		\$35.80
9		RBEM12669/P-1-03	Hoisting Tool Handle -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	-		0 pcs	0 pcs	0 pcs	\$9.00/pcs	
Line Item Note		parts made from 4140								
10		RBT18560-5	Screw -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	-		0 pcs	0 pcs	0 pcs	\$1.89/pcs	
Line Item Note		parts made from Grade B7 Medium-strength Steel								
	170702			Firmed	3/1/18	6 pcs	0 pcs	6 pcs	\$1.89/pcs	\$11.34
Sub Total:						6	0	6		\$11.34
11		RBT18582	T/R G/B Torque Adapter -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2	-		0 pcs	0 pcs	0 pcs	\$9.00/pcs	



Certificat de Conformité / Certificate of Compliance

(007034-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007034 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
07-Mar-2018		Aman		PO039090				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3700-C-01 Rev.	RBE350A94-3700-C-01 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18	0	0	0
2	RBE350A94-3700-A-03 Rev.	RBE350A94-3700-A-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	24	24	0	0	0
3	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	10	10	0	0	0
4	RBE350A94-3700-C-03 Rev.	RBE350A94-3700-C-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	9	9	0	0	0
5	RBST2120-9 Rev.	RBST2120-9 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
6	RBST1007-9 Rev.	RBST1007-9 BLACK OXIDE FINISH, MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
7	RBE350A93-3303-02-5 Rev.	RBE350A93-3303-02-5 01-BLACK OXIDE ON SST MIL-DTL-13924D BLACK OXIDE FINISH, MIL-C-23942C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
8	RBE350A93-3303-02-7 Rev.	RBE350A93-3303-02-7 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	20	20	0	0	0
10	RBT18560-5 Rev.	RBT18560-5 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
11	RBT18582 Rev.	RBT18582 ZINC PLATE, ASTM B633 TYPE 1 SC2	ZINC CH	6	6	0	0	0
13	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18	0	0	0

DA6
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9-89



Certificat de Conformité / Certificate of Compliance

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Livré à / Ship to

DART AEROSPACE LTD
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 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.		
07-Mar-2018		Aman		PO039090		
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details	Description pièce(s)	CATG. U/M	Quantités / Quantities		
	Job # / Ref #			Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty
						Qté Scrap/
						À venir/ Back Order

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.